986/4

United States
Department of
Agriculture

Food Safety
and Inspection
Service

July 11, 1986 thru
July 28, 1986

Compilation of Meat and Poultry Inspection Issuances

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The period covered in this Issuance is July 11, 1986, through July 28, 1986.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE | 43-86 | 7-25-86

FINISHED PRODUCT STANDARDS (FPS) PROGRAM

This notice is to inform inspection and plant monitoring personnel of the importance of administering the Finished Product Standards (FPS) program in all New Line Speed (NELS) and Streamlined Inspection Systems (SIS) plants.

The FPS program, which replaced the Acceptable Quality Limits (AQL) program with the New Line Speed (NELS) and Streamlined Inspection Systems (SIS), presented unfamiliar procedures and terminology to both plant and inspection personnel. A learning situation was immediately needed which was provided by the Slaughter Inspection Standards and Procedures Division and the Program Training Division, Meat and Poultry Inspection Technical Services. Flow charts, available from each of the Regional Offices, have been designed to aid in understanding the actions required in enforcing the rules associated with the FPS program. The regional implementation teams have been given special training material to aid in training plant personnel and inspectors so the FPS will be uniformly administrated. An important part of the FPS program is the time frame used to examine and record the results for the ten-bird subgroup sample. It has been determined that a trained, experienced person can perform and record the prechill FPS subgroup sample in a time period of 8 to 10 minutes. A postchill FPS subgroup sample can be completed in 5 to 7 minutes. These time periods may be longer for those birds that have a large number of processing and trim nonconformances.

Inspectors in charge should review both prechill and postchill tests and determine the times used to perform and record the subgroup sample. **Monitoring personnel** having times outside of these time frames **should be** correlated to achieve uniformity in the administration of the FPS program.

Acting Deputy Administrator
Meat and Poultry Inspection Operations

DISTRIBUTION: All MPI Office T/A Inspectors, Plant Mgt. T/A Plant Mgt., Science & Compliance Offices, Import Offices, TRA, ABB, R&E	**NOTICE EXPIRES:** 7-25-87	**OPI:** MPITS/Slaughter Inspection Standards and Procedures Division

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D. C.

FSIS NOTICE | 44-86 | 7-28-86

REMOVAL OF MATURE CHICKEN HEADS BEFORE POST-MORTEM INSPECTION

This notice is to inform the Meat and Poultry Inspection Operations (MPIO) personnel and poultry processors that the heads of mature chickens may be removed before post-mortem inspection provided that the inspector in charge has determined at ante-mortem inspection that such removal will not affect post-mortem disposition.

In 1981, the Agency reviewed the reasons for requiring that the heads of mature chickens remain on for post-mortem inspection and determined that heads are rarely needed to make a proper disposition of diseased carcasses. MPI Bulletin 81-25 was issued on June 5, 1981, which stated that heads were no longer required to be present on mature chickens at post-mortem inspection. MPI Bulletin 81-25 was cancelled on June 30,1983, but the information in the Bulletin was never included in the meat and poultry inspection manual. This notice is issued to restate the information contained in MPI Bulletin 81-25.

The heads of mature chickens are no longer required to be on for post-mortem inspection. However, permission to remove the heads from a particular group or lot of mature chickens may be rescinded by the inspector in charge or a designee if the heads are needed to make proper disposition.

This notice becomes effective immediately upon issuance. An FSIS Directive will be issued later.

Deputy Administrator
Meat and Poultry Inspection Operations

DISTRIBUTION:	NOTICE EXPIRES:	OPI:
All MPI Offices T/A Inspectors, Plant Mgt., T/A Plant Mgt., Science & Compliance Offices, Import Offices, R&E, TRA, ABB	7-28-87	MPITS/Slaughter Inspection Standards and Procedures Division

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE | 7124.1 | 7-28-86

STANDARDS OF IDENTITY OR COMPOSITION--USE OF COOKED OR CURED PRODUCT

I. PURPOSE

This directive provides procedures for determining appropriate standards of identity or composition for products containing cooked or cured ingredients.

II. CANCELLATION

Sections 19.2 and 18.35 of the Meat and Poultry Inspection Manual are superseded by this directive.

III. [RESERVED]

IV. REFERENCES

Sections 319.105(b), 381.157, 381.158, and 381.167 of the Meat and Poultry Inspection Regulations.

V. CURED PRODUCT

A. When cured meats are used in fabricated products for which minimum meat requirements have been established, the amount of added substances must be considered when calculating the formula on a fresh-weight basis.

B. Chopped Ham, Pressed Ham and Spiced Ham may not contain more than 25 percent shank meat over that normally present in boned ham. Twelve percent shank meat is considered representative of boneless whole ham. An additional allowance of 25 percent would equal 3 percent of whole ham ingredient. First determine the weight of whole ham ingredient in each batch of chopped ham, and allow the addition of 3 percent of this weight in shank meat.

VI. COOKED PRODUCT

A. The amount of meat or poultry rolls to be used in meat or poultry food products to comply with cooked meat requirements can be calculated as follows:

DISTRIBUTION: All MPI Offices, T/A Processing Inspectors, Processing Plant Management, Science and Compliance Offices, ABB, TRA, R&E, Import Offices

OPI: MPITS/Standards and Labeling Division

$$\frac{(PR)\ (CMR)\ (PY)}{RM} = \text{amount of roll required}$$

PR = Protein Ratio (See Table 1 below)
CMR = Cooked meat requirement
PY = Processing yield of roll
RM = Percent raw meat in roll

TABLE 1
Protein Ratios (Cooked to Raw)

Beef or Pork	1.44
Chicken	1.39
Turkey	1.31

B. Cooked meat may be used in meat food products when the label or standard is stated in terms of fresh meat, using the following procedures.

1. The necessary amount of raw meat is weighed and cooked at the processing plant and/or the inspector can verify that all cooked meat components (soluble solids, melted fat) from stated amount of raw meat are added to the formula.

2. If meat is not cooked at the plant and/or the inspector cannot verify the amount of raw meat represented by the cooked portion, use substitution percentage of cooked meat for fresh meat in certain protein ranges. (See Cooked Meat Equivalency Table 2 at VI, B, 2, b.) Cooked meat percentage is adjusted to allow for conversion to whole ounces.

a. **Amount.** To determine the amount of cooked meat to be used, the plant may:

(1). Test each lot (of cooked meat) before use and adopt formulas according to Table 2.

(2). Establish a procedure to assure that one of the ranges in Table 2 is being maintained, use a standardized formula based on that range, and select sufficient samples to insure cooked meat.

(3). Use a test and control procedure, approved by the Meat and Poultry Inspection Technical Services, Processed Products Inspection Division, of smaller equivalent ranges in Table 2.

b. **Sampling.** To verify plants' testing procedures, the inspector sends samples to the laboratory as necessary.

TABLE 2
Cooked Meat Equivalency Table

Laboratory results of cooked meat protein (percent).	Fresh meat equivalency of cooked meat (percent).
23.9 - under	100
24 - 28.9	75
29 - 31.9	62.5
32 - 35.9	56.25
36 - over	50

Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

CHANGE TRANSMITTAL SHEET

[X] DIRECTIVE
[ ] REVISION
[X] AMENDMENT
[ ] OTHER

FSIS DIRECTIVE STANDARDS AND LABELING DIVISION POLICY MEMORANDA	7220.1 Amend. 18	7-11-86

I. PURPOSE

This document transmits changes to FSIS Directive 7220.1.

II. CHANGES

Insert Policy Memos 097 and 098 in numerical order in attachment 1 of FSIS Directive 7220.1.

III. CANCELLATIONS

A. Policy Memo 064 is cancelled.

B. This change transmittal is cancelled when contents have been incorporated.

Director
Standards and Labeling Division
Meat and Poultry Inspection Technical Services

2 Attachments

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices. Import Offices. R&E. ABB

OPI: MPITS - Standards and Labeling Division

United States Department of Agriculture

Food Safety and Inspection Service

JUN 4 1986

To Branch Chiefs
Standards and Labeling Division

Policy Memo 097

From Margaret O'K. Glavin
Director
Standards and Labeling Division

Margaret O'K. Glavin

Subject Label Approval Guidelines for Wild Boar Products

ISSUE: What are the criteria and requirements for product labels bearing the term "Wild Boar"?

POLICY: Products prepared from wild boar from feral swine are amenable and subject to the meat inspection regulations.

"Wild Boar" is an acceptable label term for a product provided the words "Wild Boar" are directly followed by the statement "Meat from Feral Swine." The statement "Meat from Feral Swine" must appear prominently on the principle display panel as described in 9 CFR 317.2(d)(1)(2) and (3). If the statement "Meat from Feral Swine" does not directly follow the term "Wild Boar," then an asterisk may be included with the term "Wild Boar" and the statement "Meat from Feral Swine" should appear prominently elsewhere on the principal display panel. "Wild Boar from Feral Swine," "Wild Boar Meat* *from Feral Swine," "Wild Boar (byproduct) from Feral Swine," are also acceptable product names.

In order to obtain approval for a product label bearing the name "Wild Boar from Feral Swine," or similar acceptable names, a statement describing and verifying the following physical and environmental characteristics typical of wild boar is required: color patterns such as white stripes or spots, longer bristly haircoat, elongated snout with visible tusks, a "razorback" body shape and wild boar males which are uncastrated. (We acknowledge both males and females under the term "Wild Boar.") The purchased hogs should be obtained from a nonrestrictive environment which permits foraging for uncultivated feed, natural selection and breeding and farrowing without confinement. A letter should be submitted with "Wild Boar from Feral Swine" labels describing the environment where such swine live and

their method of capture or entrapment. These same criteria would also apply to imported "Wild Boar Meat from Feral Swine" and arrangements should be made through Foreign Programs for slaughter and export from approved establishments.

In multi-ingredient products, such as "Beans in Sauce with Wild Boar," the "Wild Boar" part of the product name must be followed by an asterisk and a statement "(Meat or meat byproduct) from Feral Swine" must appear somewhere on the principal display panel. The ingredient wild boar, wild boar meat, or wild boar byproduct, must be listed as "Wild Boar* ((Meat or meat byproduct) From Feral Swine)" in the ingredient statement in its proper order of predominance.

RATIONALE: There are an increasing number of products entering the market which purport to contain wild boar. The Agency recognizes that extensive interbreeding between domestic and European wild boar hog types occurs and thus dilutes any true wild boar line. However, the Agency recognizes that these hog crosses do have distinguishing characteristics resembling wild boar and it finds that "Wild Boar, Meat from Feral Swine" is an accurate labeling description of these hogs and the resulting pork.

United States Department of Agriculture

Food Safety and Inspection Service

JUN 10 1986

To: Branch Chiefs, SLD

Policy Memo 098

From: Margaret O'K. Glavin, Director
Standards and Labeling Division

Margaret O'K. Glavin

Subject: Labeling and Use of Beef Cheek Meat and Beef Head Meat

ISSUE: What guidelines should be followed for the labeling and use of beef cheek meat and/or beef head meat?

POLICY: This policy memo replaces Policy Memo 064. The following guidelines apply to the use and labeling of beef cheek meat and beef head meat:

1. "Beef Cheek Meat" refers to beef cheeks from which the glandular material has been removed.

2. "Beef Head Meat" refers to muscle tissue remaining on the beef skull after removal of the skin, cheeks, tongue, and lips. The meat normally attached to and considered as part of "tongue trimmings" when detached from the tongue trimmings may also be included as "Beef Head Meat" although it can be labeled as "beef."

3. When "beef cheek meat" and/or "beef head meat" is included in boneless beef their presence must be specifically declared. Examples include "Boneless Beef - Contains Beef Cheek Meat and Beef Head Meat," "Boneless Beef Head Meat." "Boneless Beef - Ingredients: Beef, Beef Head Meat, Beef Cheek Meat," or "Boneless Beef - 20 percent Beef Head Meat, 15 percent Beef Cheek Meat."

4. Beef cheek meat and/or beef head meat may be used in unlimited quantities and identified as "beef" in meat food products unless restricted by regulatory standards for specific products as indicated in 9 CFR 319.15, 319.81, 319.100, 319.300, 319.301, and 319.303.

RATIONALE: Beef cheek meat and beef head meat are considered to be beef and are used and declared as beef in most processed meat products. There are certain restrictions on the use of beef cheek meat and beef head meat and ingredient declaration is required for certain products by the regulations.

Since the use of the ingredient does not diminish the nutritional quality of these products beef cheek meat and beef head meat are included in the definition of beef which was published in a rulemaking proposal (48 FR 15927, April 13, 1983). Therefore, it seems appropriate that products containing beef cheek meat or beef head meat be handled in a uniform manner unless subject to specific requirements. Furthermore, since boneless beef containing beef cheek meat and/or beef head meat may be incorrectly used by a processor in restricted products, the boneless beef must be descriptively labeled to identify their presence.

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

10,100.1	7-16-86

ANALYTICAL METHOD INTRODUCTION

I. PURPOSE

This Directive prescribes FSIS policy concerning the adoption and use of new chemistry analytical methods by FSLD laboratories.

II. (RESERVED)

III. REASON FOR ISSUANCE

To prescribe how new chemistry analytical methods will be introduced into FSLD laboratories and to identify organizational responsibilities.

IV. (RESERVED)

V. FORMS AND ABBREVIATIONS

The following will appear as abbreviated in this Directive:

CD	Chemistry Division
EPA	Environmental Protection Agency
EP	Exploratory Program
FDA	Food and Drug Administration
FSL	Field Service Laboratory
FSLD	Field Service Laboratories Division
MSD	Mathematics and Statistics Division
PREB	Planning, Review and Evaluation Branch
REPD	Residue Evaluation and Planning Division
SCI	Science Program
PMB	Program Management Branch

VI. POLICY

This Directive identifies the system used within SCI for authorizing the use of new chemistry analytical methods by FSLD laboratories, either methods developed and/or evaluated within a FSL, or methods from other sources. This Directive standardizes that process.

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, R&E, TRA, ABB

OPI: SCI/Chemistry Division

VII. PROCEDURES/RESPONSIBILITIES

This section describes procedures to follow and identifies responsibilities for carrying out the prescribed procedures.

A. **Source of Methods.** Analytical methods may originate from sources such as CD, FDA, New Animal Drug Applications, EPA, FSLD laboratories, literature, etc. The need to introduce a new analytical method to a FSLD laboratory may be suggested by any FSIS program area having responsibilities for product testing. The decision to introduce a method will be the responsibility of the Deputy Administrator, SCI.

B. **Introduction Process.** The following major activities are required in the analytical method introduction process. (See Attachment 1.) To meet unusual, emergency program needs or exploratory program sampling, the CD will authorize the use of non validated chemical methods referenced in FSIS Directive 10,110.1, Data Reporting for Nonvalidated Chemical Methods (NVCM).

1. A decision to recommend to the Deputy Administrator, SCI, introduction of an analytical method will be made jointly by the Directors of CD, FSLD, and REPD if it is a chemistry residue method, during the program planning process. The approval of the Deputy Administrator, SCI, is required prior to the method's introduction.

2. CD responsibilities are to:

a. Identify and recommend purchase of instrumentation, equipment and special chemical requirements according to Science policy.

b. Conduct a technical review of the method.

c. Provide leadership and technical guidance in initial laboratory evaluations, if needed.

d. Prepare project schedule charts for method introduction in conjunction with FSLD.

e. Prepare, update, and distribute a method information sheet to involved laboratories and staffs. (See Attachment 2.)

f. Identify critical analytical operations and conduct a safety hazard analysis in conjunction with FSLD.

g. Publish the method in the chemistry guidebook in conjunction with FSLD.

h. Prepare a quality assurance plan, including analyte sensitivity, stability and tissue preservation requirements, in conjunction with FSLD.

i. Design and coordinate a method evaluation study (validation or collaborative). (See Attachment 3 for protocol format.)

j. Design in cooperation with FSLD, an analyst familiarization protocol.

k. Make a recommendation to the Deputy Administrator, SCI, to conduct EP or pilot study in a FSLD laboratory (ies).

3. FSLD responsibilities are to:

a. Identify the laboratory(ies) that will receive the analytical method.

b. Participate with CD in the preparation of project charts.

c. Schedule time for training, introduction, etc.

d. Acquire equipment and supplies.

e. Participate with CD in identifying critical analytical operations and in conducting a hazard analysis.

f. Participate in design of studies for, and conducting familiarization, validation and collaborative studies.

g. Participate with CD in writing the method in guidebook format.

h. Participate with CD in preparing the quality assurance plan.

4. MSD responsibilities are to:

a. Participate in design of method evaluation study.

b. Perform or review statistical analysis of results.

5. REPD responsibilities are to (for residue methods):

a. Recommend method introduction following sucessful evaluation based on sampling program requirements.

b. Schedule required times in the residue sampling program for training, method evaluation, analyst familiarization, etc.

c. Schedule sampling programs.

Ronald E Engel
Deputy Administrator
Science Program

Attachments
1 Science Project Schedule
2 Method Information Sheet
3 Protocol Format

SCIENCE PROJECT SCHEDULE	TITLE OF PROJECT: Method Introduction - Decision Date:
EVENTS AND ACTIVITIES	RESPONSIBLE SUPPORT PERSON
Identify and recommend purchase of equipment and supplies	PMB/FSLD
Memo to D.A. to introduce method	Director, CD & FSLD, Approval by DA, SP
Identify FSLD Laboratories	Director, FSLD
Identify FSLD Project Officer	FSLD
Identify CD Project Officer	CD, FREB
Publish method in the Chemistry Guidebook	CD/FSLD
Prepare update reports as needed, and distribute method and method information sheet	PREB
Prepare method evaluation and/or familiarization protocol, and data entry instructions	PREB
Prepare method introduction project schedule chart	PREB/FSLD
Conduct method evaluation studies and evaluate data	CD, FSLD, MSD
Evaluate method validation data	CD
Distribute data evaluation report	CD

APPROVALS	PROJECT OFFICER	DIVISION DIRECTOR	DEPUTY ADMINISTRATOR	REVISION 1	REVISION 2	REVISION 3
INITIALS						
DATES						

DIVISION

OBJECTIVE AND ACCOMPLISHMENT NUMBERS _____

DIVISION DIRECTOR'S PERFORMANCE ELEMENT AND ACTIVITY NUMBERS _____

EDITION DATE (11/81)

SCIENCE PROJECT SCHEDULE	TITLE OF PROJECT: Method Introduction - Decision Date:												
EVENTS AND ACTIVITIES	RESPONSIBLE SUPPORT PERSON												
Prepare quality assurance plan	PREB												
Decision to conduct EP, pilot study, or monitoring study	REPD or other program if non-residue												
Schedule of samples	REPD and/or other program area if non-residue												
Implement QA program	PREB/FSLD												

APPROVALS	PROJECT OFFICER	DIVISION DIRECTOR	DEPUTY ADMINISTRATOR	REVISION 1	REVISION 2	REVISION 3
INITIALS						
DATES						

DIVISION

OBJECTIVE AND ACCOMPLISHMENT NUMBERS

DIVISION DIRECTOR'S PERFORMANCE ELEMENT AND ACTIVITY NUMBERS

EDITION DATE (11/81)

METHOD INFORMATION SHEET

Revision Date: _____

Compound: _____

Compound Class or Use: _____

Method Reference: _____

Method Type: Screening _____ Quantitation _____ Confirmation _____

Method Status: NADA Study* _____ Validation _____ Collaborative _____

Analyst Qualification _____

Dates of Method Studies:

Date introduced to FSLD laboratory _____

FSLD laboratory capability: Eastern ____ Midwestern ____ Western ____

Number of Analysts to be qualified: Eastern ____ Midwestern ____ Western ____

Residue Tolerance _____ or Action Level _____

SPECIES	TISSUE	LEVEL

Method Applicability (Species/tissue, fluid): _____

_____

Recovery Range: _____

Repeatibility CV: _____

Reproducibility CV: _____

Lowest Detectable Level (LDL): _____

Lowest Reportable Level: _____

Minimum Proficiency Level (MPL): _____

Report Official Results to _____ significant figures.

Analytical Range _____

*Includes New Pesticides

	Single Samples	Multiple Samples	No. of Samples
Analytical Time:			
Elapsed Time:			

Residue Extraction/Cleanup Technique _____

_____

_____

Detection Technique: _____

_____

_____

Major (be specific) Equipment Required: _____

_____

_____

Safety Precuations: _____

_____

_____

_____

_____

ORIGINATOR OF PROTOCOL:_____

OBJECTIVE (Statement of):_____

_____

_____

_____

_____

_____

PURPOSE:

a) Method Feasibility_____

b) Method Validation_____

c) Analyst Familiarization_____

d) Method Collaborative Study_____

e) Exploratory_____

f) Correlation Study_____

g) Analyst Qualification_____

h) Other (specify)_____

LABORATORIES:

a) EL_____

b) MWL_____

c) WL_____

d) Other_____

FS LABORATORY SECTIONS:

a) Chemistry_____

b) Microbiology_____

c) Pathology_____

NUMBER OF ANALYSTS:

a) Total_____

b) Each Laboratory_____

SPECIES:

a) Beef _____

b) Calf _____

c) Swine _____

d) Chicken _____

e) Turkey _____

f) Other _____

MATRIX:

a) Muscle _____

b) Kidney _____

c) Liver _____

d) Fat _____

e) Skin _____

f) Blood (specify) _____

g) Urine _____

h) Other _____

SAMPLES:

a) Total Number _____

b) Number Each Laboratory - Familiarization _____

c) Number Each Analyst - Familiarization _____

d) Number of Study Samples Each Laboratory _____

e) Number of Study Samples Each Analyst _____

f) Total Analyses _____

g) Total Analyses Each Analyst _____

h) Number Blank Samples Each Analyst _____

i) Number Fortified _____

j) Number of Incurred Analyte Each Analyst _____

REPLICATE ANALYSIS:

a) Yes _____

b) No _____

c) If a), how many _____

d) Blind _____

e. Known _____

RESULTS REPORTING:

Forward to: _____

RESPONSIBLE INDIVIDUALS:

	TASK	INDIVIDUAL
1.		
2.		
3.		
4.		
5.		
6.		
7.		
8.		
9.		
10.		

SCHEDULE:

a) Expected Starting Date _____

b) Expected Completion Date _____

c) Expected Report Date _____

SPECIAL INFORMATION (Optional) (i.e., expected performance criteria):

_____

_____

_____

_____

_____

_____

ATTACHMENTS:

1. Method(s) _____

2. Data Entry Directions _____

3. Data Reporting Form _____

4. Relevant Background Material _____

5. Other (specify) _____

CONCURRENCES (as Applicable, please check)

(Check)

_____ a) Chemistry Division _____ Date _____

_____ b) Field Service Laboratories Division _____ Date _____

_____ 1. Eastern Laboratory _____ Date _____

_____ 2. Midwestern Laboratory _____ Date _____

_____ 3. Western Laboratory _____ Date _____

_____ c) Food Ingredient Assessment Division _____ Date _____

_____ d) Mathematics and Statistics Divison _____ Date _____

_____ e) Microbiology Division _____ Date _____

_____ f) Pathology and Epdiemiology Division _____ Date _____

_____ g) Residue Evaluation and Planning Division _____ Date _____

_____ h) Other Programs _____ Date _____

APPROVAL

Deputy Administrator for Science _____ Date _____

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

11,240.5
REV. 1

7-28-86

PLASTIC POULTRY DEBONING CONES

I. PURPOSE

This Directive describes the sanitary condition in which plastic cone deboning conveyors must be maintained for use in federally inspected poultry plants.

II. CANCELLATION

FSIS Directive 11,240.5, dated 7/24/85

III. REASON FOR ISSUANCE

To provide instruction to inplant personnel regarding sanitary levels for the plastic-type cone deboning conveyors.

IV. REFERENCES

MPI Regulation 381.53

V. USE OF CONES

Plastic cones are used to support poultry carcasses during processing. The cones are susceptible to cuts, nicks and damage made by plant personnel's knives and poultry bones. Because particles of meat, fat, and other matter accumulate on damaged surfaces, it is difficult to clean the cones. The accumulated residue is not only unsightly, but also provides a substrate for bacterial growth that can contaminate product. Also, small pieces of plastic can adhere to product.

VI. REQUIRED CONDITION AND MAINTENANCE OF CONES

A. Acceptable plastic deboning cones are smooth to the touch, impervious, and are not discolored with tissue residues after cleaning. Rough and damaged cones or cones with residual discoloration after cleaning should be refinished or replaced.

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, Import Offices, TRA, ABB, R&E

OPI: MPITS/Facilities, Equipment and Sanitation Division

B. The inspector in charge should require thorough cleaning of undamaged plastic deboning cones during each mid-shift cleanup period.

C. The inspector in charge and the plant manager should agree on a refinishing or replacement schedule to insure that cones are maintained in the required condition.

Deputy Administrator
Meat and Poultry Inspection Operations

UNITED STATES DEPARTMENT OF AGRICULTURE
FOOD SAFETY AND INSPECTION SERVICE
WASHINGTON, D.C.

FSIS DIRECTIVE

11520.2 Revision 1	7-17-86

EXPOSED HEAT-PROCESSED PRODUCT; EMPLOYEE DRESS

I. PURPOSE

This directive describes the FSIS policies and minimum sanitation procedures that are necessary to prevent contamination of exposed heat-processed products by employee's outer work garments.

II. CANCELLATION

FSIS Directive 11520.2, dated 6/11/85.

III. REASON FOR REISSUANCE

To clarify responsibilities and procedures for compliance regarding outer garments in exposed heat processed product areas in official establishments.

IV. REFERENCES

Meat and Poultry Inspection Regulations: Sections 308.8(a) and (d), 381.61(b), and 381.65(a).

V. REGULATORY REQUIREMENTS

Sections 308.8 (a) and (d), 381.61 (b), and 381.65 (a) of the Meat and Poultry Inspection Regulations provide that operations and procedures involving the preparation, storing, or handling of any product shall be according to clean and sanitary methods. In addition, the regulations provide that garments worn by persons who handle any product shall be clean.

The following are FSIS' policy guidelines and procedures, and alternative procedures which will assure compliance with the applicable regulations.

DISTRIBUTION: All MPI Offices, T/A Inspectors, Plant Management, T/A Plant Management, Science and Compliance Offices, TRA, ABB, R&E

OPI: MPITS/Facilities, Equipment and Sanitation Division

VI. POLICY

A. Clean outer garments as specified by Section IX of this directive will be worn by personnel whose activities may otherwise result in direct or indirect contamination of exposed heat-processed products or product contact surfaces.

B. Employees (e.g., box assemblers, fork lift operators) not handling exposed heat-processed products or food contact surfaces and inspectors who observe operations without product or equipment contact are not subject to the guidel'nes of this directive. These personnel must not handle exposed product unless they wash and sanitize their hands and put on clean frocks or other acceptable outer garments.

VII. DEFINITIONS

A. Heat Processed Products. Nonshelf-stable products that have been heated to a temperature of 140° F. or higher. For purposes of this directive, "heat processed products" does not include:

1. Shelf stable dry products and "keep refrigerated" semi-dry products, such as dry salami, summer sausage, and pepperoni that are not heated to 140° F. during their production,

2. Smoked bacon that is processed below 140° F. (but bacon that is fried at 140° F. or higher is included).

3. Smoked pork items, such as hams, shoulders, picnics, and loins that are processed, cooled, and boxed as whole units. (However, if such smoked items are divided, sliced, or cubed, they are included once they leave the cooler and enter the processing room.)

B. **Outer Garments.** Any garment that may directly or indirectly contact product or otherwise carry contaminants to product.

C. **Sanitized.** The application of an antimicrobial agent to the arms and hands to reduce microbial levels. The compounds must be coded E2 or E3 in the List of Proprietary Substances and Nonfood Compounds and must be used according to label instructions or Agency guidelines.

VIII. RESPONSIBILITIES

A. **Inspector-In-Charge (IIC).** In accordance with sections 308.8 and 381.61 of the meat and poultry inspection regulations, the IIC shall:

1. Assure that employees of establishments engage in the production of heat processed products are attired in clean outer garments at the start of each shift.

2. Require outer garments to be changed during the shift if:

a. Contacted by unclean objects or materials.

b. Excessively soiled with product residue.

c. Removed from areas where exposed product is heat-processed to a place where they may have become contaminated: Provided, however, that outer clothing is permitted in areas within the plant (e.g., cafeterias, locker rooms, offices, connecting corridors) in which the risk of contamination is minimal. Outer garments should not be worn by processing employees into cafeteria areas used by slaughter employees, restrooms, storage rooms, maintenance areas or other such areas of the plant where contamination may occur. If they are, such garments will be considered as sources of potential contamination if worn into an area with exposed product. The IIC may restrict access to these areas of any person suspected of wearing such potentially contaminating outer garments.

Note: To preclude questions of insanitation from outer garmets worn outside processing areas, plant management may wish to require that, when the employee(s) leave the processing department for any reason, the outer garment may be hung in a designated area that will prevent garment contamination. The location must be acceptable to the IIC. The garments may then be reused when the employee(s) return to the department.

B. Assigned Inspector(s)

1. Continuously set a good example for plant personnel by personally following the guidelines in this directive to assure a clean outer garment when product or equipment contact is necessary.

2. Periodically, confirm that clean clothes are worn by employee(s).

3. Report noncompliance to the IIC and/or take appropriate actions to obtain compliance as delegated by the IIC.

IX. COMPLIANCE

An operation would be in compliance if the employees specified in this directive wear any of the following:

A. Long sleeved frock that covers long sleeved garments or bare arms and extends below the product zone. The frock is replaced or removed as specified in paragraph A. of this section.

B. Half-length jacket with full length sleeves and bib apron that extends below the product zone. The jacket and apron must be replaced or removed as specified in paragraph A. of this section.

C. Two-piece uniform with short sleeves (clean pants and shirt, skirt and blouse) that are put on in the plant, removable sleeves, and bib apron that extends below the product zone. The removable sleeves and bib apron must be replaced or removed as specified in paragraph A. of this section.

D. Two-piece uniform with short sleeves (clean pants and shirt, skirt and blouse) that are put on in the plant and bib apron that extends below the product zone. The apron must be replaced or removed as specified in paragraph A. of this section. The exposed arms up to and including the elbows, but not the upper arms above the elbow, must be washed and sanitized each time the employee enters or reenters the operation, and each time an arm contacts a contaminated object.

E. Frock with short sleeves. The frock must be removed or replaced as specified in paragraph A. of this section. The exposed arms up to and including the elbows, but not the upper arms above the elbow, must be washed and sanitized each time the employee enters or reenters the operation and each time an arm contacts a contaminated object.

F. Long sleeved coveralls, jumpsuits, etc., must be covered with a long sleeved frock. Short sleeved coveralls, jumpsuits, etc., may be covered with a short sleeved frock. The frock must be removed or replaced as specified in paragraph A. of this section. The exposed arms up to and including the elbows, but not the upper arms above the elbow, must be washed and sanitized each time the employee enters or reenters the operation, and each time the arms contact a contaminated object.

James K. Payne

Deputy Administrator (for)
Meat and Poultry Inspection Operations